

Date: Wednesday, 12/11/2008 1:37:41 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: COMFORT SEAT- FRAME		
Job Number	: 43357		Part Number	: D37521		
Estimate Number	: 13369		Drawing Number	: D3752		
P.O. Number	:		Project Number	: N/A		
This Issue	: 12/11/2008	S.O. No. :	Drawing Revision	: C		
Prsht Rev.	: NC		Material	:		
First Issue	: / /		Due Date	: 08/12/2008		
Previous Run	: 42057		Qty:	1 Um: Each		
Written By	:					
Checked & Approved By	: <u>JDO 08.11.12</u>					
Comment	: Est. REV: A New Issue 08.06.03 DL verified by:DD Est Rev. B Dwg. Update 08/07/22 DL Est. Rev. C Dwg. Update Shorter length 08/10/28 DL					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
Comment: HAND FINISHING THERMOFORMING			
	Set up machine program D3752-1		
	Set up clamping frame as per folio		
2.0	MLEXS125F6002904	GE PLASTICS LEXAN SHEET	
Comment: Qty.: 10.6670 sf(s)/Unit Total : 10.6670 sf(s)			
	GE PLASTICS LEXAN SHEET		
3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING	
Comment: HAND FINISHING THERMOFORMING			
	1) Cut Blanks		
4.0	THERMOFORMING	THERMOFORMING MACHINE	
Comment: THERMOFORMING MACHINE			
	Thermoform as per Dwg. D3752 and Folio		

Dwg. Rev. C
 Folio Rev. C

BB 08/11/13 X1

#1

BB 08/11/14 X1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 12/11/2008 1:37:41 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COMFORT SEAT- FRAME

Job Number: 43357

Part Number: D37521

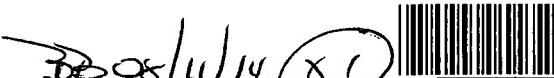
Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



BB 08/11/14 X1

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0 HAND FINISH TH HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/11/17 X1

7.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT TRIMMED PARTS

1) Check dimensions to ensure conformity to drawing tolerances.

BB 08/11/17 X1

8.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/11/17 X1

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

STQ63

88 08/11/18 X1

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/11/18 X1

Job Completion



MF 08-11-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	WORK ORDER:	13357
Description: Seat Frame	Part Number:	D3752-1
Inspection Dwg: D3752 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

(Step 4) Thermoforming Visual Inspection Sign-off

Description	Initials
	✓
Acceptable shape definition	✓
Free of visual flaws (bumps, cracks, voids, etc.)	✓
	✓

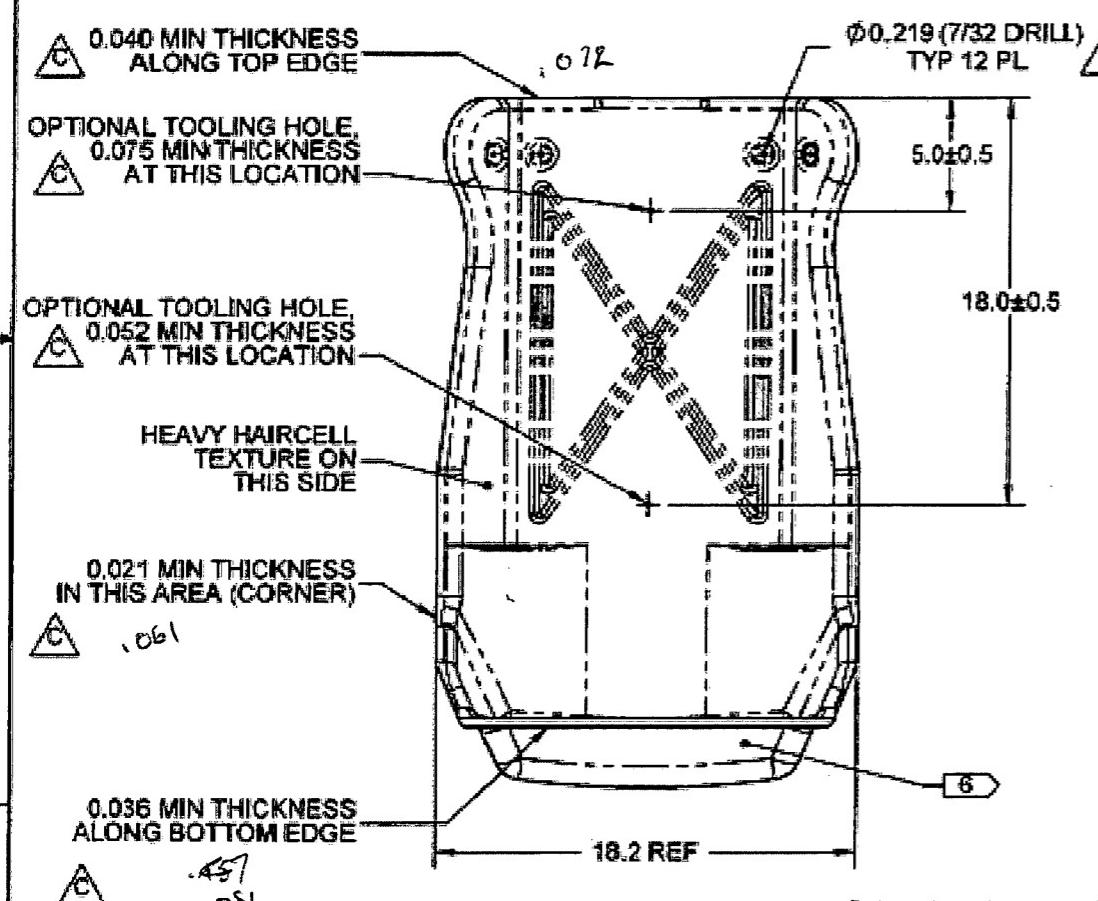
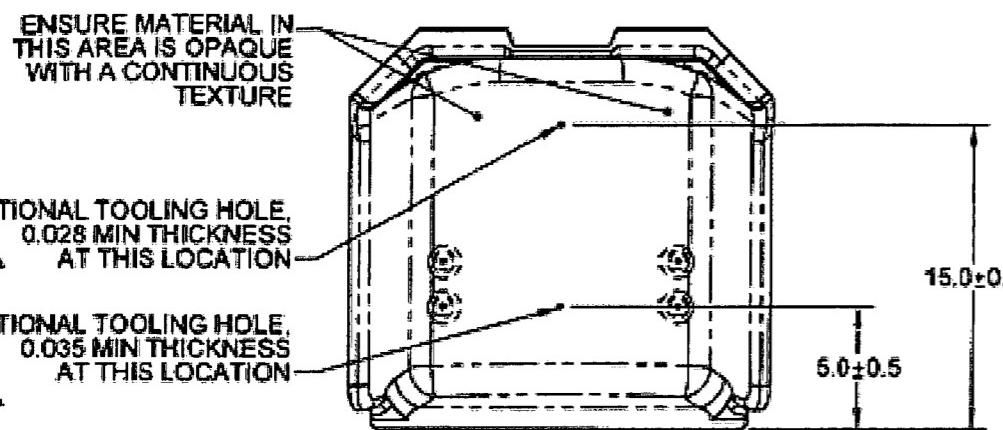
(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing _____ Rev. __ and record below

Drawing	Tolerance	Actual	Accept	Reject	Method of Inspection	Comments
Dimension		Dimension				
0.028"	MIN	.034	✓			尺寸
0.035"	MIN	.047	✓			尺寸
0.040"	MIN	.072	/			尺寸
0.075"	MIN	.108	✓			尺寸
0.052"	MIN	.082	/			尺寸
0.021"	MIN	.061	/			尺寸
0.036"	MIN	.081	/			尺寸
						增加
						增加
						增加
						增加

Measured by:	Pat B	Audited by:	D	Prototype Approval:	1 / 4
Date:	08/11/17	Date:	08/11/17	Date:	11/11/17

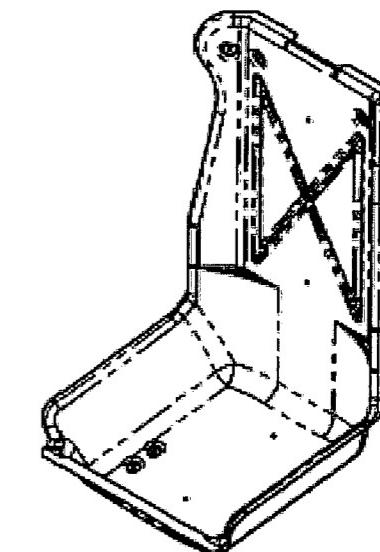
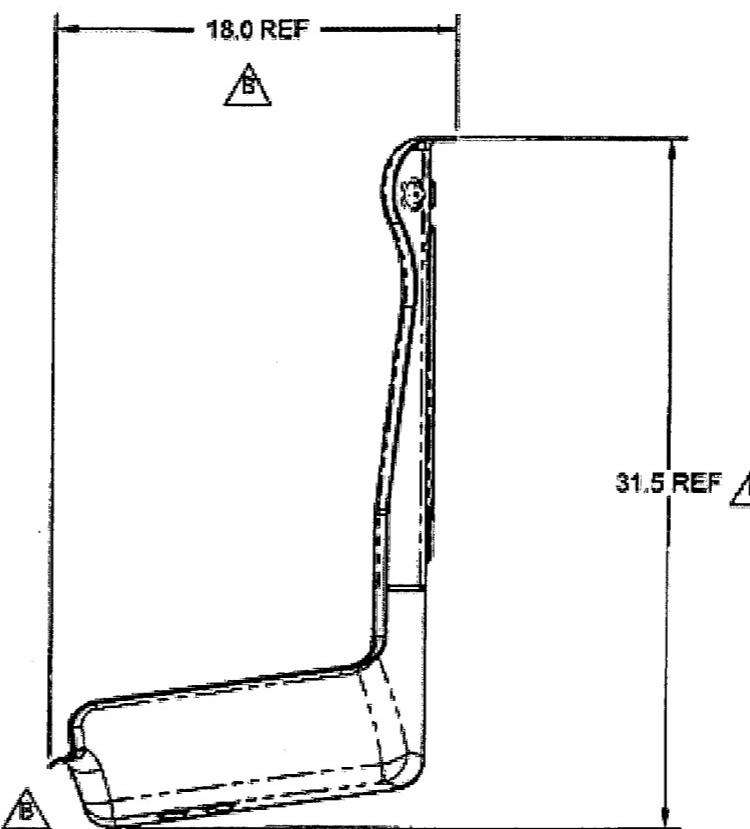
Rev	Date	Change	Revised by	Approved
		New Issue		



D3752-1 SEAT FRAME

NOTES:

- 1) MATERIAL: F60029 LEXAN SHEET (HEAVY HAIRCELL TEXTURE), 0.125 THICK, GY3778 COLOR (DARK GREY) (REF DART SPEC. MLEXS.125-F60029-04).
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3752-1" & B/N "BXXXXX" USING VIBRATING STYLUS
- 7) WEIGHT: 3.0 lbs
- 8) THERMOFORM PER DT8997 AND QSI 022. ORIENT TEXTURE AS SHOWN. TRIM TO MOLD.



RELEASED
08/11/05
10/05

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 43357

C	REDUCE THICKNESS: 0.040 WAS 0.050 (IN CB-1), 0.075 WAS 0.100 (CB-1), 0.052 WAS 0.090 (BB-1), 0.021 WAS 0.030 (BB-1), 0.036 WAS 0.060 (AB-1), 0.028 WAS 0.035 (DB-1), 0.035 WAS 0.050 (DB-1). SOME HOLES NOW OPTIONAL (AB-1 TO DB-1)	CP	08.10.08
B	FRONT PORTION NOW SHORTER (B5-1). 18.0 WAS 19.6 (C4-1), 31.5 WAS 30.3 (B3-1). ADD 4 HOLES FOR THICKNESS MEASUREMENT (DB-1, BB-1)	CP	08.09.09
A	NEW ISSUE	CP	08.04.25
REV.	DESCRIPTION	BY	DATE
DESIGN	9/	DART AEROSPACE LTD	
DRAWN	9/	HAWKESBURY, ONTARIO, CANADA	
CHECKED	9/	DRAWING NO.	REV. C
MFG. APPR.	9/	D3752	SHEET 1 OF 1
APPROVED	9/	TITLE	SCALE
DE APPR.	9/	SEAT FRAME	NTS
DATE	08.10.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	